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D3507-1-BENT
Job Sheet 202344



Part No: D3507-1-BENT

Job Qty: 6 pcs

Part Name: Skidtube Assembly EC135



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/25/19

Job Tracking No:

Due Date: 12/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP rev A 10.09.17 new issue EC verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Skidtubes - Bend - 1	6 pcs	12/4/19	12/4/19	0.33	3.53	Skidtubes - Bend		M/SQJ TF
140	QC 5	6 pcs	12/4/19	12/4/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BF
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
300	Packaging 3-1 - Stock - B4B	6 pcs	12/4/19	12/4/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



Container No: S232835



Part: D3507-1-BENT

Job No: 202344

Serial No/Batch: S232835

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 11/18/19

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				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
310 QC 21 - SA	6 pcs	12/4/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	8.53

NOV 18 2019

Part Op 120 - (CNC Delta 100 Bender), 1- Bend tube as per program D3507 on CNC Bender FOLIO 6 and Dwg D3507, use
 Descriptions: DT9632 bending aide 2- Cut FWD END of tube as per dwg D3507

140 - (QC5- Inspect part completeness to step on W/O)

300 - (Identify as per dwg & Stock Location: LG002, LOCATION : LG002

310 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2962-150	3.540 Outer Tube, Extrud	6 pcs (1 ea)	120-Skidtubes - Bend - 1	5175497

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Skidtubes - Bend - 1	D2962-150	6	41	0

Part Specifications

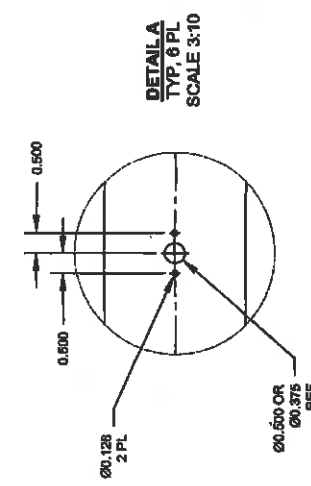
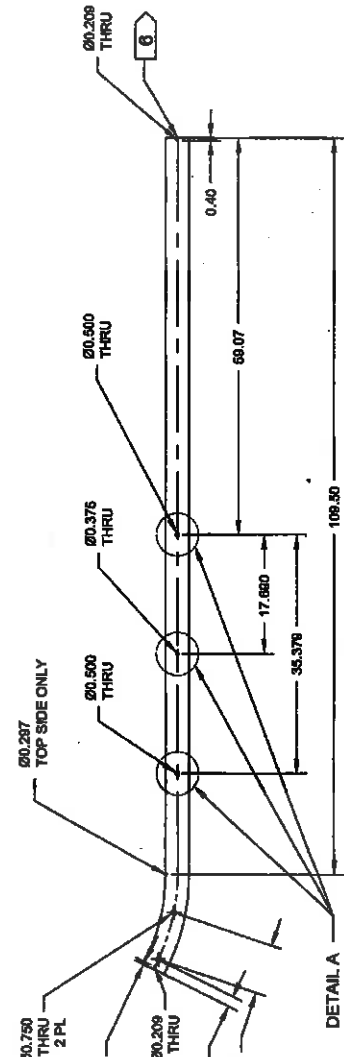
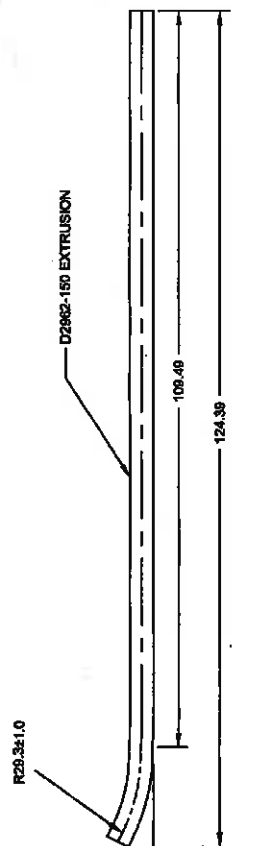
Specifications could not be found.

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Qty	Part Number	Description
X	D3507-011	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D4162-041	PLUG ASSEMBLY
4	D4162-043	PLUG ASSEMBLY
2	D4162-047	PLUG ASSEMBLY
2	D5004-1	CROSS BOLT SPACER
1	D5004-3	CROSS BOLT SPACER
2	D5004-5	CROSS BOLT SPACER
1	D5006-1	WEB
4	D5006-3	DOUBLER
2	D5006-5	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	ALS-1032-150	INSERT
1	ALS-1032-225	INSERT
31	AN304A	BOLT
2	AN305A	BOLT
2	AN306C1032-19	SCREW
33	AN660C101	WASHER
42	AN660C104WS	RIVET

- GENERAL NOTES:**
- 1) MATERIAL: ALUMINUM CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING
 - 2) FINISH: D3507-1 WEB
 - 3) STANDARD: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2. OPTIONAL: POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
 - 4) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
 - 5) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.003 TO 0.010 MAX
 - 7) IDENTIFICATION: IDENTIFY WITH DART EN PER DART QSI 044 8.4 (VIBRATING STYLUS) ON ID. OF TUBE
 - 8) WEAR TO BE (FROM D198-751)
 - 9) WEAR TO BE (FROM D198-751)
 - 10) INSERT DART QSI 016 TO LOCATE AND DRILL 90.297 HOLES (28 PLACES) FOR WEARSHOE INSERTS. INSTALL ALS-1032-150 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-2411-291.
 - 11) DO NOT INSTALL AN304A BOLTS AND AN660C101 WASHERS IN INDICATED LOCATIONS

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 202344 MS
19-11-18



D	REMOVE D3506-X GASKETS, D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH, REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.08.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	08.11.01
A	NEW ISSUE	PH	09.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW		
CHECKED	DW		
MFG. APPR.	D3507		
APPROVED			
DE APPR.			
DATE	13.08.30		
DART AEROSPACE USA, INC KENT, WA DRAWING NO. D3507 SHEET 1 OF 2 TITLE EC 135 SKIDTUBE SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS TO BE USED FOR THE PROJECT AND NOT BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.			

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐		Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐		Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐		Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐									
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)													
Description Work Order Deviation				Disposition															
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐				Pressure/Forced ☐ ☐ ☐ ☐ ☐ Bending ☐ ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐ ☐				Contamination ☐ ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐ ☐				Power Loss/Surge ☐ ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐ ☐				Positioned Wrong ☐ ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐ ☐			
				FAULT CATEGORY															
				Other/Details: _____															
Completed By				Lead hand / Supervisor				QC / QA Coordinator											